

## CLAIMS

1 An apparatus for forming curved laminations, comprising:

a planar horizontal surface;

a first die board, said first die board having a planar lower surface, a first

5 curved upper surface, a first predetermined thickness, first and second

sides and first and second ends;

said planar lower surface being disposed upon said planar horizontal surface;

a plurality of lamination support members, said support members having

parallel top and bottom surfaces, first and second sides, first and second

10 ends, a second predetermined thickness;

said bottom surfaces of said lamination support members being disposed upon

said first curved upper surface of said first die board; and

whereby, when the planar lower surface of said first die board is disposed upon

said horizontal surface and said lamination support members are

15 disposed upon the first curved upper surface of the first die board with

the bottom surface adjacent the second end of the lamination support

members disposed upon the horizontal surface, the top surfaces of the

lamination support members will reflect the first curved upper surface

of the first die board above a point where the lamination support

20 members contact said first upper surface and provide a curved surface

for laminating veneer portions.

2. An apparatus for forming curved laminations as described in Claim 1, further comprising:

a second die board, said second die board having a planar lower surface, a second curved upper surface, a third predetermined thickness, first and second sides and first and second ends;

said planar lower surface of said second die board being disposed upon said planar horizontal surface;

said bottom surfaces of said lamination support members being disposed upon said first and second curved upper surfaces of said first and second die boards; and

whereby, when the planar lower surfaces of said first and second die boards are disposed upon said horizontal surface and said lamination support members are disposed upon the first and second curved upper surfaces of said first and second die boards, the top surfaces of the lamination support members will reflect the first and second curved upper surfaces of the first and second die boards and provide a curved surface for laminating veneer portions.

3. An apparatus for forming curved laminations as Described in Claim 1 wherein the lamination support members are cylindrical in cross-section.

4. An apparatus for forming curved laminations as Described in Claim 1, wherein:

said lamination support members are substantially rectangular in cross-section;

said first side of said lamination support member including a rounded  
 projecting tongue and said second side of said lamination support  
 member including a mating rounded, receiving notch; and  
 whereby, adjacent lamination support members will fit more closely together  
 while following the first curved upper surface of said first die board,  
 thereby forming a smoother surface upon which veneer portions are  
 laminated.

5. An apparatus for forming curved laminations as described in Claim 1, further  
 comprising:

an insulating sheet, said insulating sheet being formed of thin, flexible,  
 resilient material;

said insulating sheet being disposed between top surfaces of the lamination  
 support members and a lower surface of a veneer portion being  
 laminated upon said lamination support members; and

whereby, when said insulating sheet is inserted between the lamination support  
 members and the lower surface of a veneer portion indentations in a lamination  
 resulting from contact with top surfaces of the lamination support members  
 will be minimized.

6. An apparatus for forming curved laminations, comprising:

a planar horizontal surface;

a first die board, said first die board having a planar lower surface, a first

curved upper surface, a first predetermined thickness, first and second

sides and first and second ends;

said planar lower surface of said first die board being disposed upon said planar

horizontal surface;

a plurality of lamination support members, said support members having

parallel top and bottom surfaces, first and second sides, first and second

ends, a fourth predetermined thickness and a first notch disposed upon

said bottom surface and spaced inwardly from said first end;

said first notch having first and second side walls and a first upper bearing

surface;

said first notch being sized and shaped to fit slidably over said first

predetermined thickness of said first die board;

said first upper bearing surface being disposed upon said first curved upper

surface; and

whereby, when the planar lower surface of said first die board is disposed upon

said horizontal surface and said first notches of said lamination support

members are disposed upon the first curved upper surface of the first

die board with the bottom surface adjacent the second end of the

lamination support members disposed upon the horizontal surface, the

top surfaces of the lamination support members will reflect the first

curved upper surface of the first die board above a point where the first

notches contact said first upper surface and provide a curved surface for laminating veneer portions.

7. An apparatus for forming curved laminations as described in Claim 6, further comprising:

a second die board, said second die board having a planar lower surface, a second curved upper surface, the first predetermined thickness, first and second sides and first and second ends;

said planar lower surface of said second die board being disposed upon said planar horizontal surface;

a second notch, said second notch being disposed upon said bottom surface and being spaced inwardly from the second end of said lamination support members;

said second notch having first and second side walls and a second upper bearing surface;

said second notch being sized and shaped to fit slidably over said first predetermined thickness of said second die board;

said second upper bearing surface being disposed upon said second curved upper surface; and

whereby, when the planar lower surfaces of said first and second die boards are disposed upon said horizontal surface and said first and second notches of said lamination support members are disposed upon the first and second curved upper surfaces of said first and second die boards, the

top surfaces of the lamination support members will reflect the first and second curved upper surfaces of the first and second die boards and provide a curved surface for laminating veneer portions.

- 5      8.      An apparatus for forming curved laminations as described in Claim 6, further comprising:

an insulating sheet, said insulating sheet being formed of thin, flexible, resilient material;

10      said insulating sheet being disposed between top surfaces of the lamination support members and a lower surface of a veneer portion being laminated upon said lamination support members; and

15      whereby, when said insulating sheet is inserted between the lamination support members and the lower surface of a veneer portion indentations in a lamination resulting from contact with top surfaces of the lamination support members will be minimized.

9.      An apparatus for forming curved laminations as described in Claim 6, wherein:

said first upper bearing surface of said first notch including a downward facing curve;

20      said downward facing curve having its lowest point at a vertical centerline of said lamination support member; and

whereby, when said first notch of said lamination support members is disposed upon said first curved upper surface of said first die board, with the

bottom surface adjacent the second end of the lamination support members disposed upon the horizontal surface, the top surfaces of the lamination support members will more accurately reflect the first curved upper surface of the first die board above the point where said downward facing curve of said first upper bearing surface of said first notch contacts said first curved upper surface and provide a curved surface for laminating veneer portions.

10. An apparatus for forming curved laminations as described in Claim 7, wherein:

said first and second upper bearing surfaces of said first and second notches including downward facing curves;

said downward facing curves having their lowest points at a vertical centerline of said lamination support member; and

whereby, when said first and second notches of said lamination support

members are disposed upon said first and second curved upper surfaces of said first and second die boards, the top surfaces of the lamination support members will more accurately reflect the first and second curved upper surfaces of the first and second die boards and provide a curved surface for laminating veneer portions.

11. An apparatus for forming curved laminations as described in Claim 6, further comprising:

a series of closely spaced cuts extending orthogonally from said first side to said second side and from said top surface toward said bottom surface of said lamination support members;

said cuts permitting said top surfaces to assume a three-dimensional contoured configuration when a three-dimensional object having said configuration on an upper surface is placed between said horizontal surface and said bottom surface of said lamination support members; and

whereby, when said object causes said lamination support members to bend, a surface having compound curves will be formed for laminating veneer portions.

12. An apparatus for forming curved laminations as described in Claim 6, wherein the first curved upper surface of the first die board includes an upward facing curve extending from the first side to the second side of said first die board.

13. An apparatus for forming curved laminations as described in Claim 6, wherein the top surface of each lamination support member includes an upward facing curve extending from the first side to the second side of said member.

14. An apparatus for forming curved laminations as described in Claim 6, wherein:



the first upper bearing surface of said first notch is formed as a portion of an  
 orifice disposed at a first predetermined distance from the top surface of  
 the lamination support member; and  
 the first and second side walls of said first notch extending upwardly from the  
 bottom surface of said support member and intersecting a lower portion  
 of a perimeter of said orifice.

15. An apparatus for forming curved laminations as described in Claim 14, wherein:

the first upper bearing surface of said first notch includes a downward facing  
 curve extending from the first side to the second side of said lamination  
 support member; and  
 said downward facing curve having its lowest point at a vertical centerline of  
 said lamination support member.

16. A method for forming curved laminations, comprising:

providing a planar horizontal surface;  
 preparing a first die board, said first die board having a planar lower surface, a  
 first curved upper surface, a first predetermined thickness, first and  
 second sides and first and second ends;  
 said first curved upper surface reflecting a desired curve for at least one end of  
 a lamination;

providing a plurality of lamination support members, said support members  
having parallel top and bottom surfaces, first and second sides, first and  
second ends, a second predetermined thickness;  
positioning the lower planar surface of said first die board upon the horizontal  
surface;  
assembling said lamination support members upon said first die board and with  
the bottom surface adjacent the second end of the lamination support  
members disposed upon the horizontal surface;  
providing an insulating sheet, said insulating sheet being formed of thin,  
flexible, resilient material and being designed to prevent indentations in  
a lamination resulting from contact with top surfaces of the lamination  
support members;  
placing said insulating sheet upon the top surfaces of the lamination support  
members;  
preparing at least two veneer portions, said veneer portions being sized and  
shaped to fit above the top surfaces of said lamination support  
members;  
providing a glue layer between said veneer portions;  
placing said veneer portions upon said insulating sheet;  
applying pressure to an upper surface of a top veneer portion;  
allowing said glue to dry; and  
removing the laminated veneer portions from the insulating sheet.

17. A method for forming curved laminations, comprising:

providing a planar horizontal surface;

preparing a first die board, said first die board having a planar lower surface, a first curved upper surface, a first predetermined thickness, first and second sides and first and second ends;

said first curved upper surface reflecting a desired curve for at least one end of a lamination;

preparing a second die board, said second die board having a planar lower surface, a second curved upper surface, a third predetermined thickness, first and second sides and first and second ends;

said second curved upper surface reflecting a desired curve for at least one end of a lamination;

providing a plurality of lamination support members, said support members having parallel top and bottom surfaces, first and second sides, first and second ends, a second predetermined thickness;

positioning the lower planar surfaces of said first and second die boards upon the horizontal surface with the first die board parallel to the second die board, said first die board being spaced from the second die board;

assembling said lamination support members upon said first and second die boards;

providing an insulating sheet, said insulating sheet being formed of thin, flexible, resilient material and being designed to prevent indentations in

a lamination resulting from contact with top surfaces of the lamination support members;

placing said insulating sheet upon the top surfaces of the lamination support members;

5 preparing at least two veneer portions, said veneer portions being sized and shaped to fit above the top surfaces of said lamination support members;

providing a glue layer between said veneer portions;

placing said veneer portions upon said insulating sheet;

10 applying pressure to an upper surface of a top veneer portion;

allowing said glue to dry; and

removing the laminated veneer portions from the insulating sheet.

18. A method for forming curved laminations, comprising:

15 providing a planar horizontal surface;

preparing a first die board, said first die board having a planar lower surface, a first curved upper surface, a first predetermined thickness, first and second sides and first and second ends;

20 said first curved upper surface reflecting a desired curve for at least one end of a lamination;

providing a plurality of lamination support members, said support members having parallel top and bottom surfaces, first and second sides, first and second ends, a fourth predetermined thickness and a first notch

disposed upon said bottom surface and spaced inwardly from said first end;

said first notch having first and second side walls and a first upper bearing surface;

5       said first notch being sized and shaped to fit slidably over said first predetermined thickness of said first die board;

positioning the lower planar surface of said first die board upon the horizontal surface;

assembling said lamination support members upon said first die board with said  
10       first notches engaging said first curved upper surface of said first die board and with the bottom surface adjacent the second end of the lamination support members disposed upon the horizontal surface;

providing an insulating sheet, said insulating sheet being formed of thin,  
15       flexible, resilient material and being designed to prevent indentations in a lamination resulting from contact with top surfaces of the lamination support members;

placing said insulating sheet upon the top surfaces of the lamination support members;

preparing at least two veneer portions, said veneer portions being sized and  
20       shaped to fit above the top surfaces of said lamination support members;

providing a glue layer between said veneer portions;

placing said veneer portions upon said insulating sheet;

applying pressure to an upper surface of a top veneer portion;  
 allowing said glue to dry; and  
 removing the laminated veneer portions from the insulating sheet.

5 19. A method for forming curved laminations, comprising:

providing a planar horizontal surface;

preparing a first die board, said first die board having a planar lower surface, a  
 first curved upper surface, a first predetermined thickness, first and  
 second sides and first and second ends;

10 said first curved upper surface reflecting a desired curve for at least one end of  
 a lamination;

preparing a second die board, said second die board having a planar lower  
 surface, a second curved upper surface, said first predetermined  
 thickness, first and second sides and first and second ends;

15 said second curved upper surface reflecting a desired curve for at least one end  
 of a lamination;

providing a plurality of lamination support members, said support members  
 having parallel top and bottom surfaces, first and second sides, first and  
 second ends, a fourth predetermined thickness and first and second  
 20 notches disposed upon said bottom surface and spaced inwardly from  
 said first end and second end, respectively;

said first and second notches having first and second side walls and first and  
 second upper bearing surfaces;

said first and second notches being sized and shaped to fit slidably over said  
first predetermined thickness of said first and second die boards;  
positioning the lower planar surfaces of said first and second die boards upon  
the horizontal surface with the first die board parallel to the second die  
board, said first die board being spaced from the second die board by a  
distance separating said first notch from said second notch;  
assembling said lamination support members upon said first and second die  
boards with said first and second notches engaging said first and second  
curved upper surfaces of said first and second die boards;  
providing an insulating sheet, said insulating sheet being formed of thin,  
flexible, resilient material and being designed to prevent indentations in  
a lamination resulting from contact with top surfaces of the lamination  
support members;  
placing said insulating sheet upon the top surfaces of the lamination support  
members;  
preparing at least two veneer portions, said veneer portions being sized and  
shaped to fit above the top surfaces of said lamination support  
members;  
providing a glue layer between said veneer portions;  
placing said veneer portions upon said insulating sheet;  
applying pressure to an upper surface of a top veneer portion;  
allowing said glue to dry; and  
removing the laminated veneer portions from the insulating sheet.

20. A method for forming curved laminations as described in Claims 16-19, wherein pressure is applied to the upper surface of the top veneer portion by inserting the apparatus for forming curved laminations together with the veneer portions with interleaved glue layer disposed upon the insulating sheet, disposed upon the top surfaces of the lamination support members, into a heavy duty, airtight plastic bag, sealing the bag and evacuating the air from the bag, thereby allowing atmospheric pressure to conform the veneer portions to the insulating sheet and the top surface of the lamination support members.

21. An apparatus for forming curved laminations, comprising:

- a desired lamination profile, said profile including a planar baseline, and an upper curve;
- said baseline having a first end, a second end, and being comprised of a series of equal-sized increments;
- said upper curve, defining a height above said baseline for each increment of the baseline from said first end to said second end;
- a plurality of adjacent lamination support members, said support members having parallel top and bottom surfaces, first and second sides, first and second ends, a fifth predetermined thickness equal to said equal-sized increment;



each of said adjacent lamination support members having a height equal to the height of the upper curve of the desired lamination profile above the baseline for one of the equal-sized increments;

means for maintaining said adjacent lamination support members in parallel alignment to one another, thereby yielding a curved surface defined by the adjacent top surfaces of said adjacent lamination support members, said curved surface being suitable for laminating veneer portions.

22. A method for forming curved laminations, comprising:

developing a desired lamination profile, said profile including a planar baseline, and an upper curve;

said baseline having a first end, a second end, and being comprised of a series of equal-sized increments;

said upper curve, defining a height above said baseline for each increment of the baseline from said first end to said second end;

providing a plurality of adjacent lamination support members, said support members having parallel top and bottom surfaces, first and second sides, first and second ends, a fifth predetermined thickness equal to said equal-sized increment;

each of said adjacent lamination support members having a height equal to the height of the upper curve of the desired lamination profile above the baseline for one of the equal-sized increments;

maintaining said adjacent lamination support members in parallel alignment to one another, thereby yielding a curved surface defined by the adjacent top surfaces of said adjacent lamination support members, said curved surface being suitable for laminating veneer portions;

5 providing an insulating sheet, said insulating sheet being formed of thin, flexible, resilient material and being designed to prevent indentations in a lamination resulting from contact with top surfaces of the adjacent lamination support members;

10 placing said insulating sheet upon the top surfaces of the adjacent lamination support members;

preparing at least two veneer portions, said veneer portions being sized and shaped to fit above the top surfaces of said adjacent lamination support members;

providing a glue layer between said veneer portions;

15 placing said veneer portions upon said insulating sheet;

applying pressure to an upper surface of a top veneer portion;

allowing said glue to dry; and

removing the laminated veneer portions from the insulating sheet.

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23. An apparatus for forming curved laminations, comprising:

a planar horizontal surface;

a first die board, said first die board having a planar lower surface, a first

curved upper surface, a first predetermined thickness, first and second

sides and first and second ends;

said planar lower surface being disposed upon said planar horizontal surface;

5 a plurality of lamination support members, said support members having top

and bottom surfaces, first and second sides, first and second ends, a

second predetermined thickness;

said bottom surfaces of said lamination support members being disposed upon

said first curved upper surface of said first die board; and

10 whereby, when the planar lower surface of said first die board is disposed upon

said horizontal surface and said lamination support members are

disposed upon the first curved upper surface of the first die board with

the bottom surface adjacent the second end of the lamination support

members disposed upon the horizontal surface, the top surfaces of the

15 lamination support members will reflect the first curved upper surface

of the first die board above a point where the lamination support

members contact said first upper surface and provide a curved surface

for laminating veneer portions.

- 20 24. An apparatus for forming curved laminations as described in Claim 23, further comprising:

a second die board, said second die board having a planar lower surface, a second curved upper surface, a third predetermined thickness, first and second sides and first and second ends;

said planar lower surface of said second die board being disposed upon said planar horizontal surface;

said bottom surfaces of said lamination support members being disposed upon said first and second curved upper surfaces of said first and second die boards; and

whereby, when the planar lower surfaces of said first and second die boards are disposed upon said horizontal surface and said lamination support members are disposed upon the first and second curved upper surfaces of said first and second die boards, the top surfaces of the lamination support members will reflect the first and second curved upper surfaces of the first and second die boards and provide a curved surface for laminating veneer portions.

25. An apparatus for forming curved laminations, comprising:

a planar horizontal surface;

a first die board, said first die board having a planar lower surface, a first curved upper surface, a first predetermined thickness, first and second sides and first and second ends;

said planar lower surface of said first die board being disposed upon said planar horizontal surface;

a plurality of lamination support members, said support members having top and bottom surfaces, first and second sides, first and second ends, a fourth predetermined thickness and a first notch disposed upon said bottom surface and spaced inwardly from said first end;

5 said first notch having first and second side walls and a first upper bearing surface;

said first notch being sized and shaped to fit slidably over said first predetermined thickness of said first die board;

10 said first upper bearing surface being disposed upon said first curved upper surface; and

whereby, when the planar lower surface of said first die board is disposed upon said horizontal surface and said first notches of said lamination support members are disposed upon the first curved upper surface of the first die board with the bottom surface adjacent the second end of the lamination support members disposed upon the horizontal surface, the top surfaces of the lamination support members will reflect the first curved upper surface of the first die board above a point where the first notches contact said first upper surface and provide a curved surface for laminating veneer portions.

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26. An apparatus for forming curved laminations as described in Claim 25, further comprising:

a second die board, said second die board having a planar lower surface, a second curved upper surface, the first predetermined thickness, first and second sides and first and second ends;

said planar lower surface of said second die board being disposed upon said planar horizontal surface;

a second notch, said second notch being disposed upon said bottom surface and being spaced inwardly from the second end of said lamination support members;

said second notch having first and second side walls and a second upper bearing surface;

said second notch being sized and shaped to fit slidably over said first predetermined thickness of said second die board;

said second upper bearing surface being disposed upon said second curved upper surface; and

whereby, when the planar lower surfaces of said first and second die boards are disposed upon said horizontal surface and said first and second notches of said lamination support members are disposed upon the first and second curved upper surfaces of said first and second die boards, the top surfaces of the lamination support members will reflect the first and second curved upper surfaces of the first and second die boards and provide a curved surface for laminating veneer portions.